

538

<b>DART AEROSPACE LTD.</b>		<b>Work Order:</b>	24126
<b>Description:</b> Saddle Fitting, Aft (Outboard/Inboard)		<b>Part Number:</b>	D2573/D2574
<b>Drawing:</b> D2573 Rev. D/D2574 Rev. D		<b>Qty:</b>	12
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	AS	05/08/80	12
2	MV	Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: B21802	JL	05.08.18	12
3	MV	Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: B21818	JL	05.08.18	12
4	MV	Fixturing W/O No. <u>          </u> Fixturing Inspection last completed <u>          </u> by <u>          </u>	JL	05.08.18	12
5	MV	Program Batch No. 24126 Double check by: E	JL	05.09.13	12
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	JL	05/09/18	12
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	JL	05/09/18	12
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	JL	05/09/18	12
9	MV	Machine keyway as per dwg D2573 & D2574	JL	05/09/18	12
10	MV	Deburr and remove all machining marks	JL	05/09/18	12
11	MV	Tumble for 20 minutes to remove sharp edges # 04.06.21	JL	05/09/12	12
12	QC1	Inspect all dimensions to dimension sheets	JL	05/09/18	12
13	QC7	Second inspection	JL	05/09/18	12
14	FP	Acid etch and alodine as per QSI 005 4.1	JL	05/09/18	12
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	JL	05/09/18	12
16	QC3	Inspect Powder Coat	JL	05/09/18	12
17	ST	Identify and Stock.	JL	05/09/18	12
18	AC	Cost / Part 150.30 113.38	JL	05/09/18	12
19	DC	Close W/O 151.62 114.75 Inspection Level 21	JL	05/09/18	12

Rev	Date	Change	Revised By	Approved
D	99.09.09	Added inspection level, Qty column	EC	
E	00.07.04	Removed P/O for powder coat, drawing change rev. C	EC	
F	00.07.20	Removed inspection level 7	EC	
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2574	KJ RF	

RELEASED  
02/10/15 RF